

Work Order ID 95569

Monday, January 14, 2013 10:50:31 AM

95569

Page 1

Item ID: D3888-1**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Full Height Comfort Window, LH**Stop*****NS2*****Start Date:** 1/14/2013 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 1/31/2013 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:** **Process Plan:** *11***Date:** *13-01-14* **Tooling:****Date:****Run Start*****NR1*****QC:****Date:****Date:****Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
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D3888	<i>PA1 A</i>								<i>DAS 07-09</i>
100		0.00							
100		HAND FINISHING THERMOFORMING							
Thermoform			Memo	0.00					
Thermoforming Machine				Set up Machine as per folio FTA130 and D3676 program					

110		0.00							<i>DAS 07-09</i>
110		HAND FINISHING THERMOFORMING							
Thermoform			Memo	0.00					
Thermoforming Machine				Cut Blanks to 30" by 48"					

120		0.00							<i>DAS 07-09</i>
120		THERMOFORMING MACHINE							
Thermoform			Memo	0.00					
Thermoforming Machine				Thermoform as per Dwg. D3888-1 and Folio FTA 130					
			Rev. <i>B</i>	Folio Rev. <i>A</i>	Dwg.				
			Visually inspect for proper formation and clarity						

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Item ID: D3888-1 Accept *N900040100* Setup Start *NS1*
Revision ID:
Item Name: Full Height Comfort Window, LH Stop *NS2*
Start Date: 1/14/2013 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 1/31/2013 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Thermoform	HAND FINISHING THERMOFORMING	0.00				1			DAS 07 9-89
Thermoforming Machine	Memo	0.00							13/01/21
160 *160* QC	QC2- Inspect parts off machine FAI/FAIB	0.00				1			DAS 07 9-89
Quality Control	Memo	0.00							13/01/21
170 *170* QC	QC5- Inspect part completeness to step on W/O	0.00							DAS 16 9-89
Quality Control	Memo	0.00							13/01/21

1) Visually inspect for clarity, and proper formation.

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Item ID: D3888-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Full Height Comfort Window, LH

Stop

NS2

Start Date: 1/14/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/31/2013 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MJS 13-02-01

N (3-02-1)

Picklist Print

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Monday, January 14, 2013 10:50:37 AM

Work Order ID: 95569

95569
D3888-1

Parent Item: D3888-1

Parent Item Name: Full Height Comfort Window, LH

Start Date: 1/14/2013

Required Date: 1/31/2013

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A New Issue 12/01/19 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRYLICS.177		Purchased		No			sf	346.6600		13.68421			

MACRYLICS 177
0.177" PLEXIGLAS G CLEAR CAST ACRYLIC SHEET

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
therm	346.66	
119505	14.66	
120972	44	
122537	288	

13/01/21
13.685 sq ft.

DART AEROSPACE LTD	Work Order:	95569
Description:	Part Number:	D3888-1
Inspection Dwg: D3888-1 Rev: A-06		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1/4"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: W.H.

Date: 13/01/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.1	± 0.100	29.1 "	✓			
46.0	± 0.100	46.1 "	✓			
0.090 "	M.N.	0.095 "	✓			

Measured by: DAS 07

Date: 13/01/14

Audited by: DAS 13/1/13

Date:

Preliminary Approval: 16/01/13

Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

8

7

6

5

4

3

2

1

D

C

B

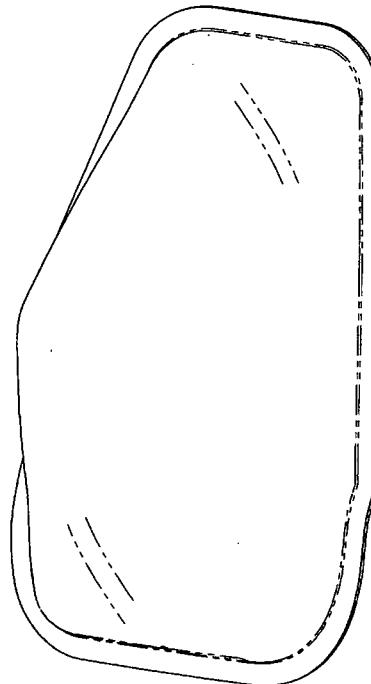
A

D

C

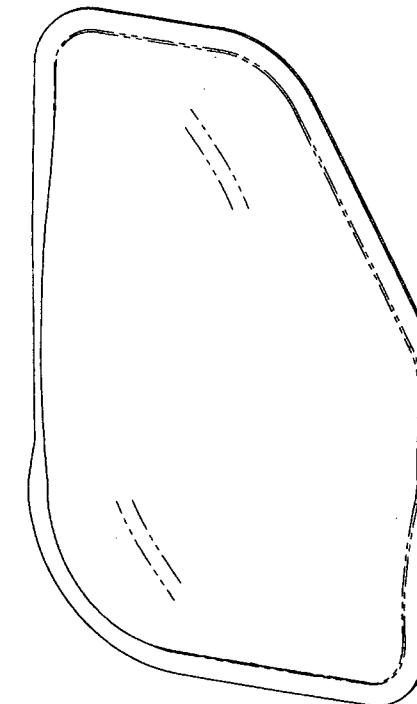
B

A



D3888-1 FULL HEIGHT COMFORT WINDOW (LH)

95569
PL 13-01-14



D3888-2 FULL HEIGHT COMFORT WINDOW (RH)

RELEASED
2012-03-06
W

A	NEW ISSUE		AP	12.03.01
REV.	DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	SP	DRAWING NO.	REV. A	
MFG. APPR.	DA	D3888	SHEET 1 OF 3	
APPROVED	SP	TITLE	SCALE	
DE APPR.	#	FULL HEIGHT COMFORT WINDOW	NTS	
DATE	12.03.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS CONFIDENTIAL INFORMATION THAT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

